

Work Order ID 129998

February-23-15 10:36:43 AM

129998

Page 1

Item ID: D2804-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 2/23/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 2/23/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 15-02-26 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2804	Rev C

100	FLOW WATER JET	0.00				(2)	φ	15/03/04	
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100
 Waterjet
 FLOW CNC Waterjet
 Memo
 1-Cut as per File D2804-1-2_BLANK
 Dwg Rev: C
 Prog Rev: C
 2-Deburr if necessary

110	HAAS CNC VERTICAL MACHINING #1	0.00				(2)	φ	15/03/04	
-----	--------------------------------	------	--	--	--	-----	---	----------	--

110
 HAAS 1
 HAAS CNC vertical machine #1
 Memo
 Machine as per folio FA103

120	QC2- Inspect parts off machine FAI/FAIB	0.00				2	φ	15-03-30	
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120
 QC
 Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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② _____ MAR 31 2015

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
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Training									
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Work Order ID 129998

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Page 3

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 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 2/23/15 Start Qty: 2.00 ***2*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location ST 45	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

DAB
27
9-30
MAR 31 2015

MCS 15-04-01
DAB-1

DQA: _____ Date: _____



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Design									
Doc/Data									
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Picklist Print

February-23-15 10:36:42 AM

Page 1

Work Order ID: 129998

129998

Parent Item: D2804-2

D2804-2

Parent Item Name: Bracket

Start Date: 2/23/15

Required Date: 2/23/15

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP A00.11.06New IssueEC

IPP B06.05.30 Blanks on wtjetEC

IPP Rev:C As per Rev C 06-11-09 JLM

IPP Rev:D Removed Tumbling 08-09-10 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B0.500X10.00
0

Purchased

No

f

19.2000

1.5

M6061T6B0 500X10 000

**

DE 15/03/04

6061-T6 Bar .500 x 10.00

Location

Loc Qty

Loc Code

MAT001

19.2

M130527

2.2

M130860

5

M131392

12

3

DQA: _____ Date: _____



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DART AEROSPACE LTD		Work Order: 129998
Description: STA 155 Bracket		Part Number: D2804-2
Inspection Dwg: D2804	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

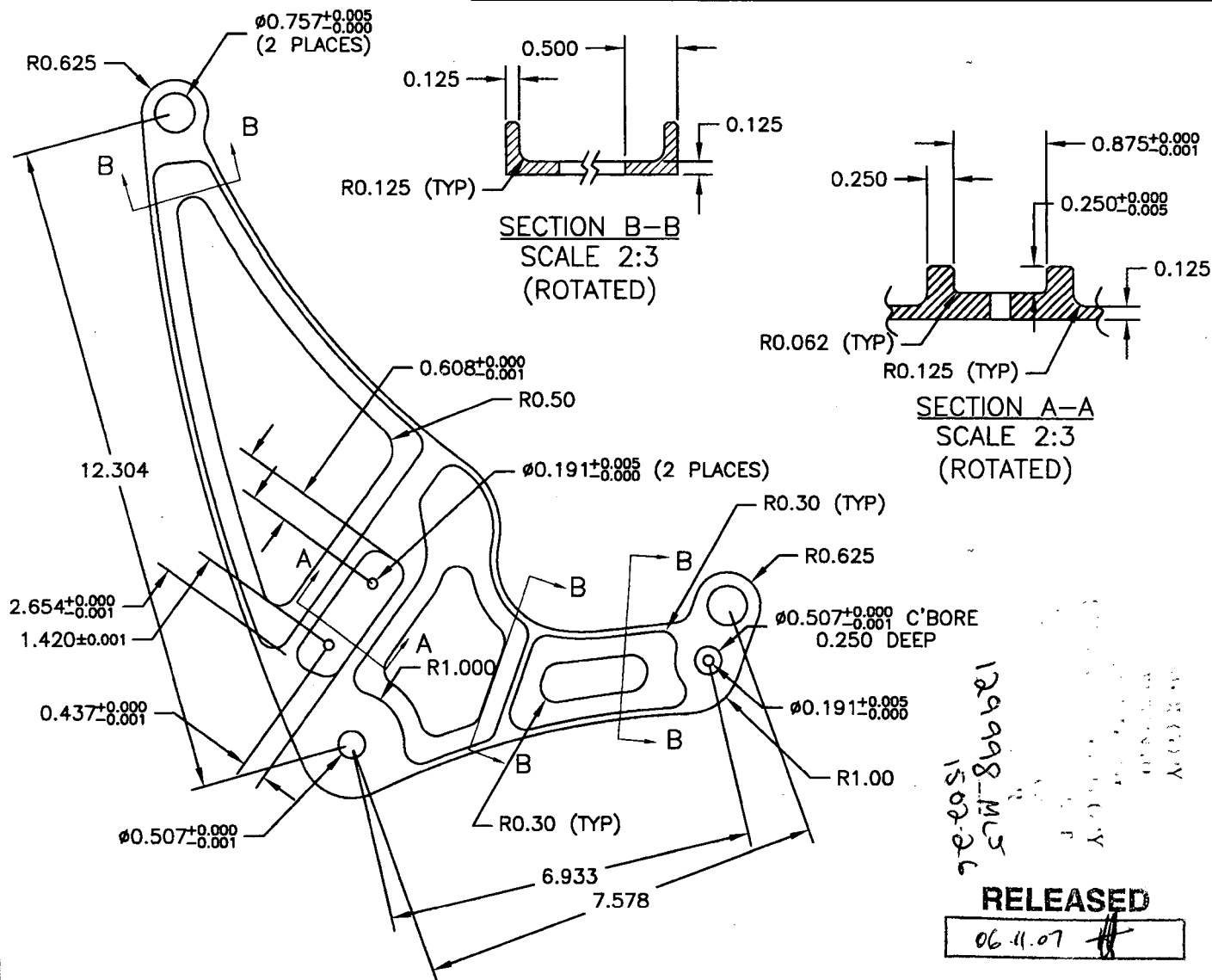
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	.130	✓		12" Vern	BC
0.125	+/-0.010	.125	✓			
R0.125	+/-0.010	.125	✓			
0.250	+/-0.010	.250	✓			
0.250	+0.000/-0.005	.246	✓			
0.875	+0.000/-0.001	.874	✓			
R0.062	+/-0.010	.062	✓			
Ø0.757	+0.005/-0.000	.758	✓			
R0.625	+/-0.010	.625	✓			
12.304	+/-0.005	12.30	✓		Tag	BC
Ø0.507	+0.000/-0.001	.506	✓			
0.437	+0.000/-0.001	.436	✓			
0.608	+0.000/-0.001	.607	✓			
Ø0.191	+0.005/-0.000	.191	✓			
1.420	+0.001/-0.001	1.419	✓			
0.250 deep	+/-0.010	.240	✓			
6.933	+/-0.005	6.935	✓			
7.578	+/-0.005	7.578	✓			
0.500	+/-0.010	.503	✓			

Measured by: BC	Audited by: J.A.	DAS	Prototype Approval:	N/A
Date: 15-05-30	Date: 15/03/31	08 9-89	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.04.25	Added 0.500 dimension	KJ/JLM	
C	06.11.10	Revised per drawing revision C	KJ/JLM	BE

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D2804
				REV. C SHEET 1 OF 2
DATE	06.10.16	TITLE	STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE		
B	04.11.22	ADD CUTOUTS & -043/-044		
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE		

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

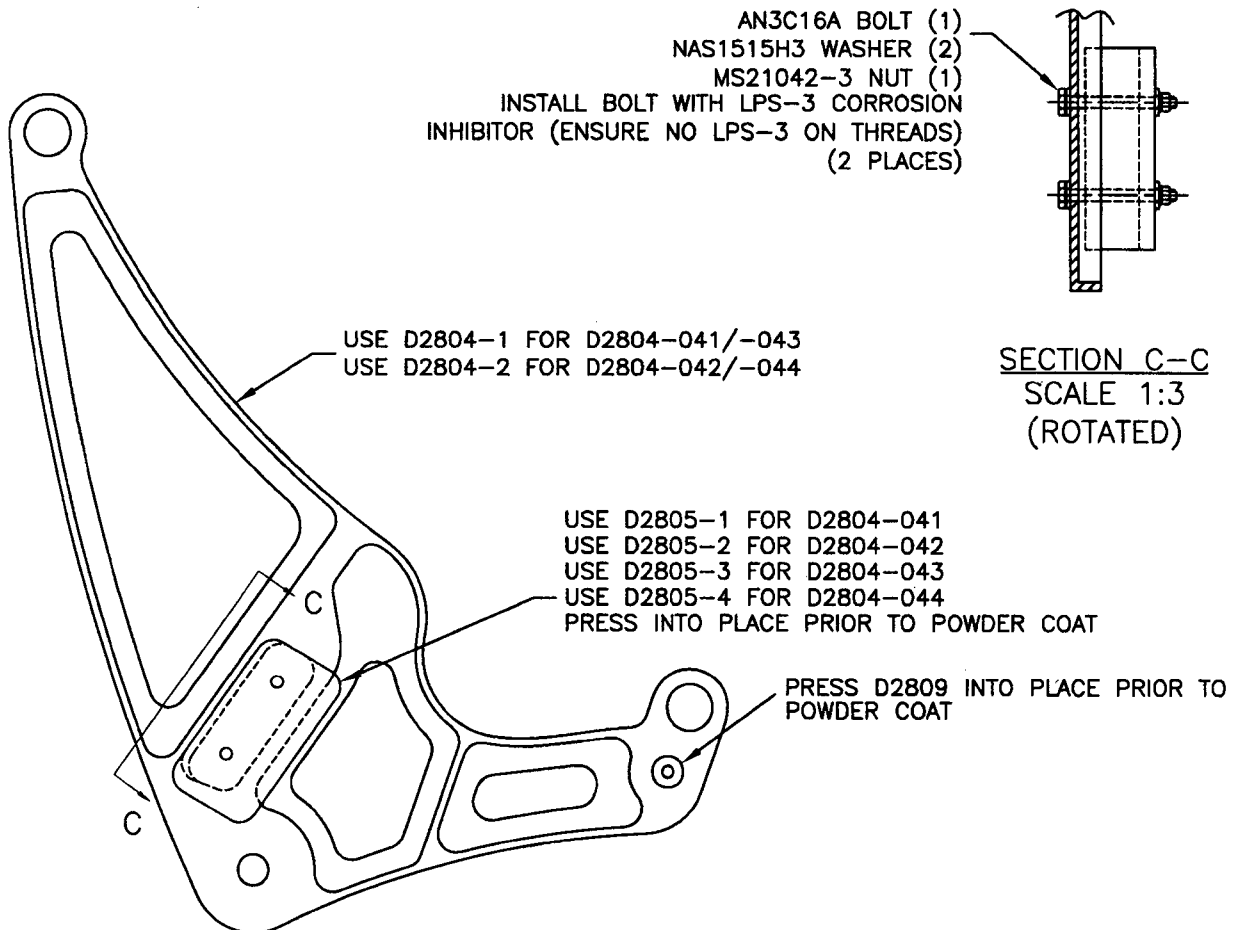
- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3

**RELEASED**

06.11.07

D2804-041/-043 BRACKET ASS'Y (SHOWN).**D2804-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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